

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024089**Date Inspected:** 23-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 13CW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3015D-084 [RS stiffener to Floor Beam (FB) fillet weld at Panel Point (PP) 124]. The welder is identified as 066687 and was observed welding in 3F position. ZPMC Quality Control (QC) was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2113-FCM-1.

The SMAW process on weld joint no: Seg3015H-176 (RS stiffener to FB fillet weld at PP123). The welder is identified as 057220 and was observed welding in 3F position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2113-FCM-1.

SMAW process on weld joint no: Seg3015K-266 [RS Stiffener to RS Stiffener (on FB); CJP splice weld at PP122.

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5]. The welder is identified as 066157 and was observed welding in 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 13BW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SA3134-001 [on Splice Plate Sub-Assembly for Seg 13CW, complete joint penetration (CJP) weld, at PP121 to 121.5]. The welder is identified as 045143 and was observed welding in 1G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-T-2231-ESAB.

The SMAW process on weld joint no: Seg3014D-229 [RS stiffener to RS stiffener (on FB); CJP splice weld, at PP121.5]. The welder is identified as 040270 and was observed welding in 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
